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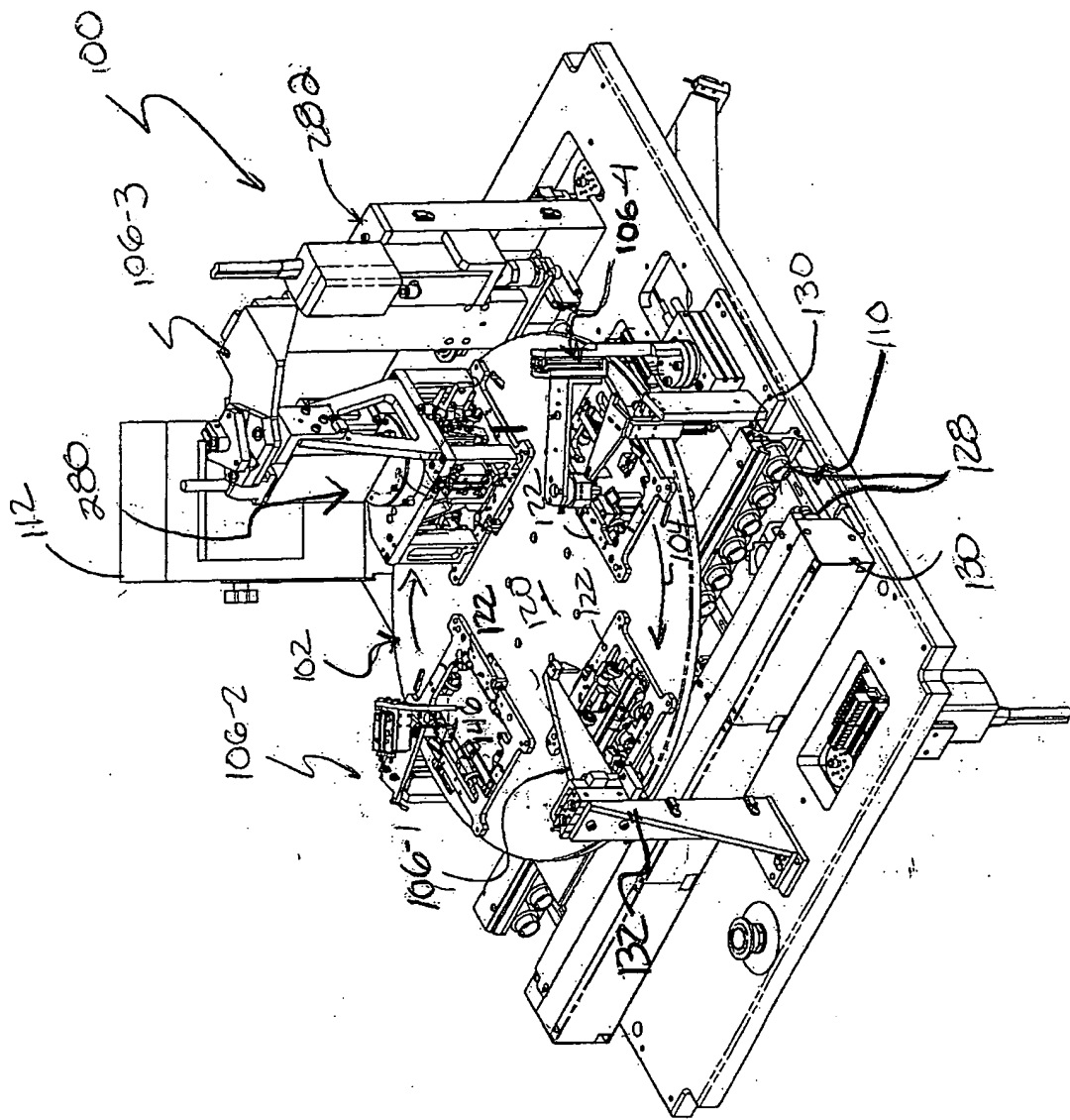


FIG. 1

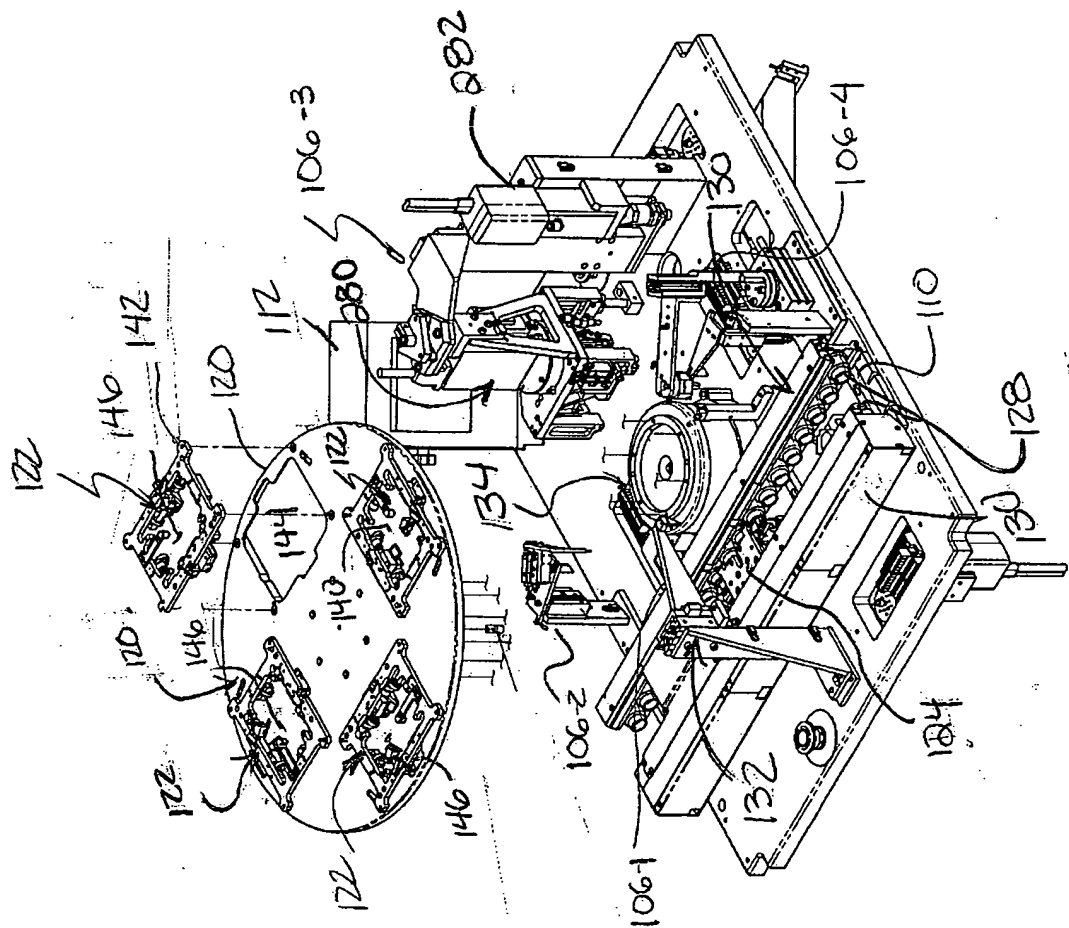


FIG. 2



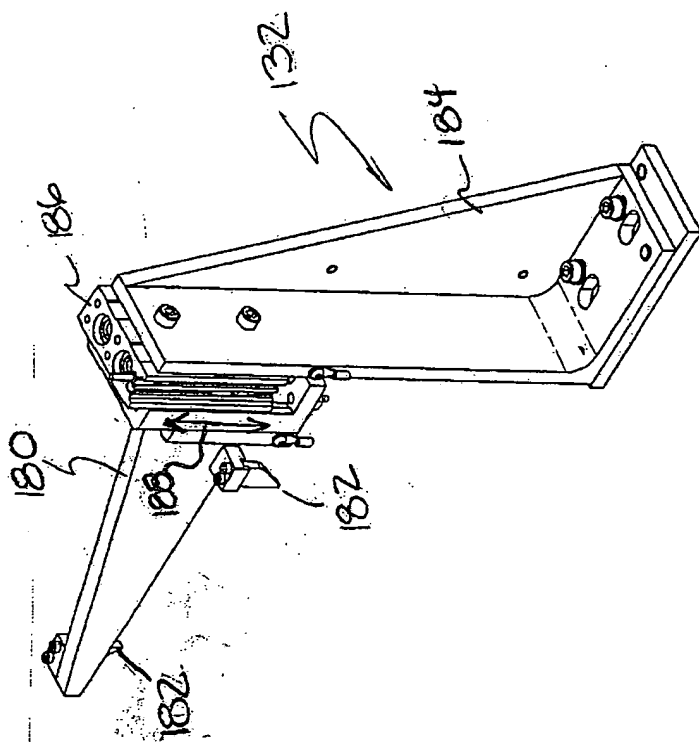
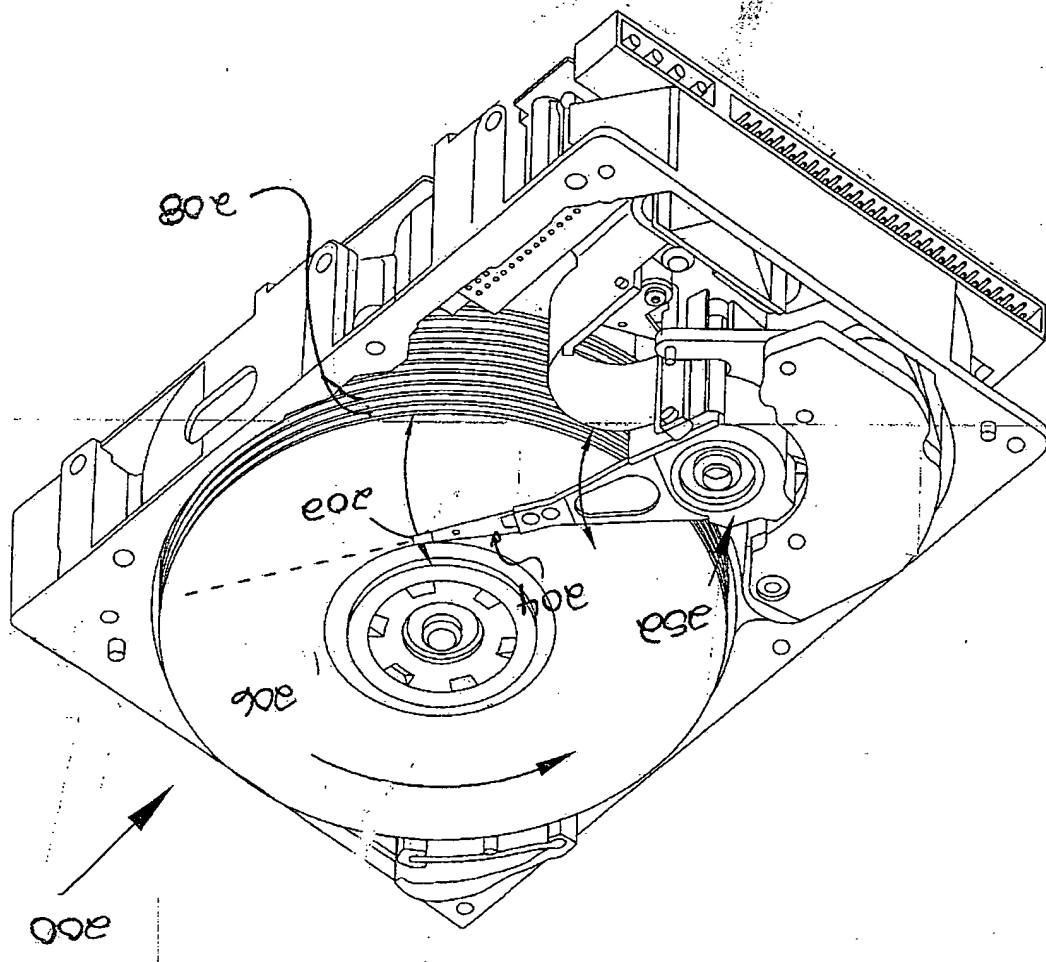


FIG.4

FIG. 5





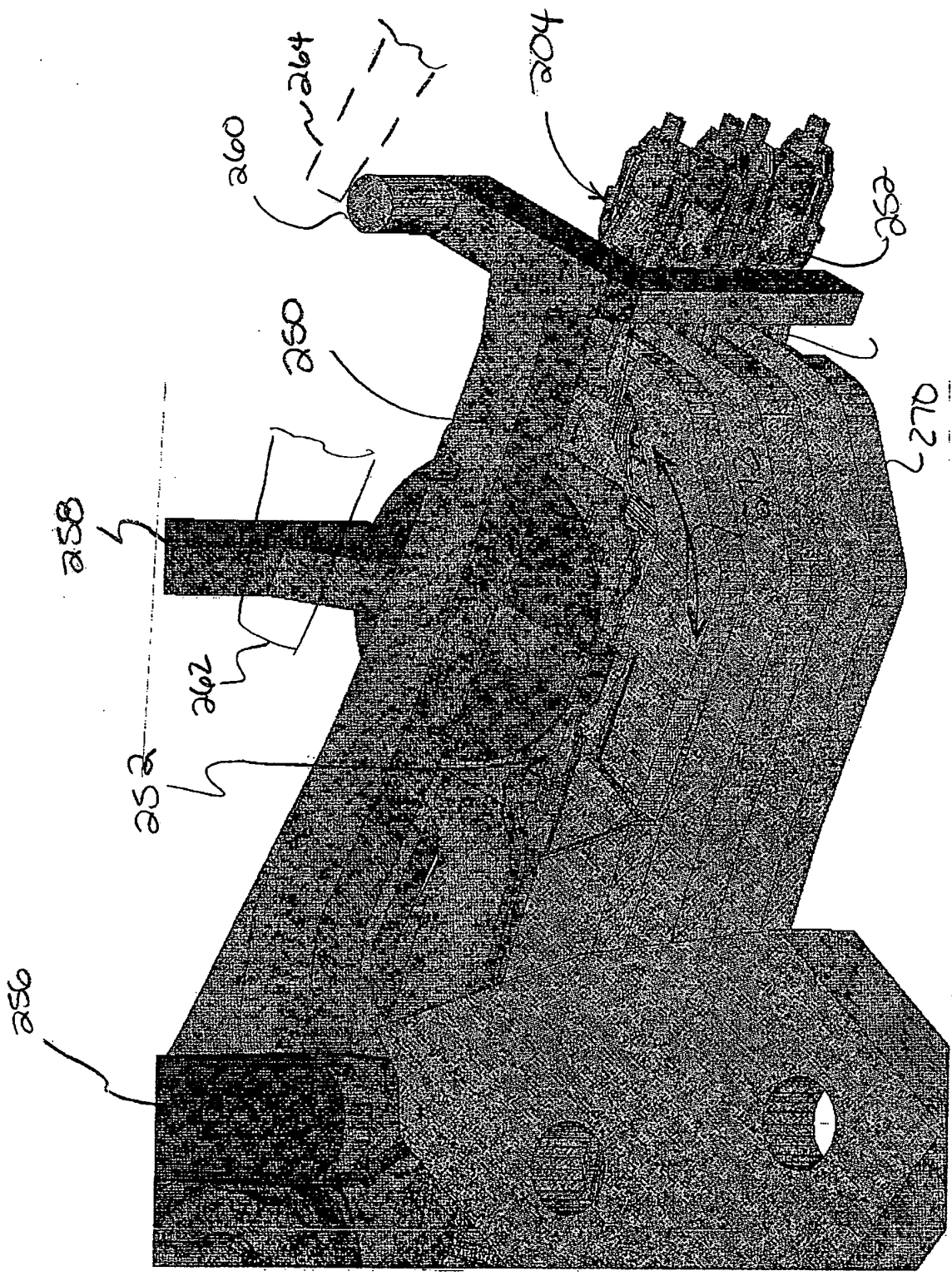


FIG. 7



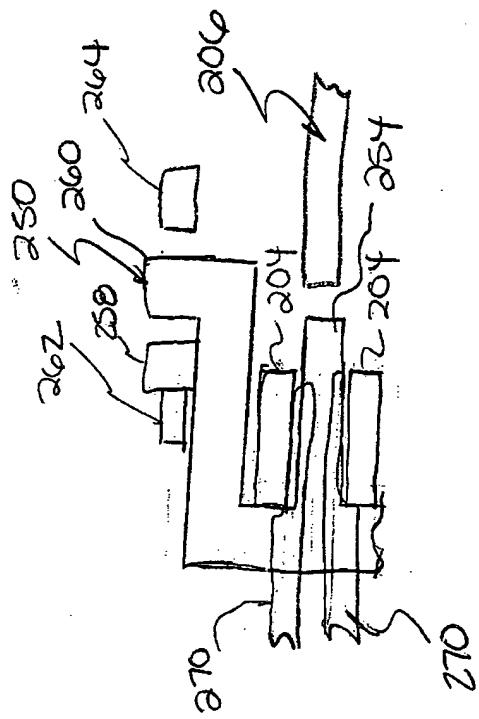


FIG. 8

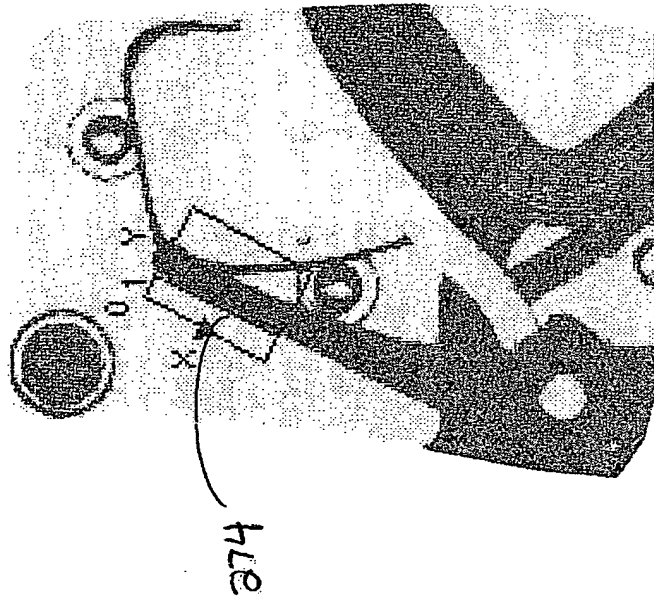


FIG. 9

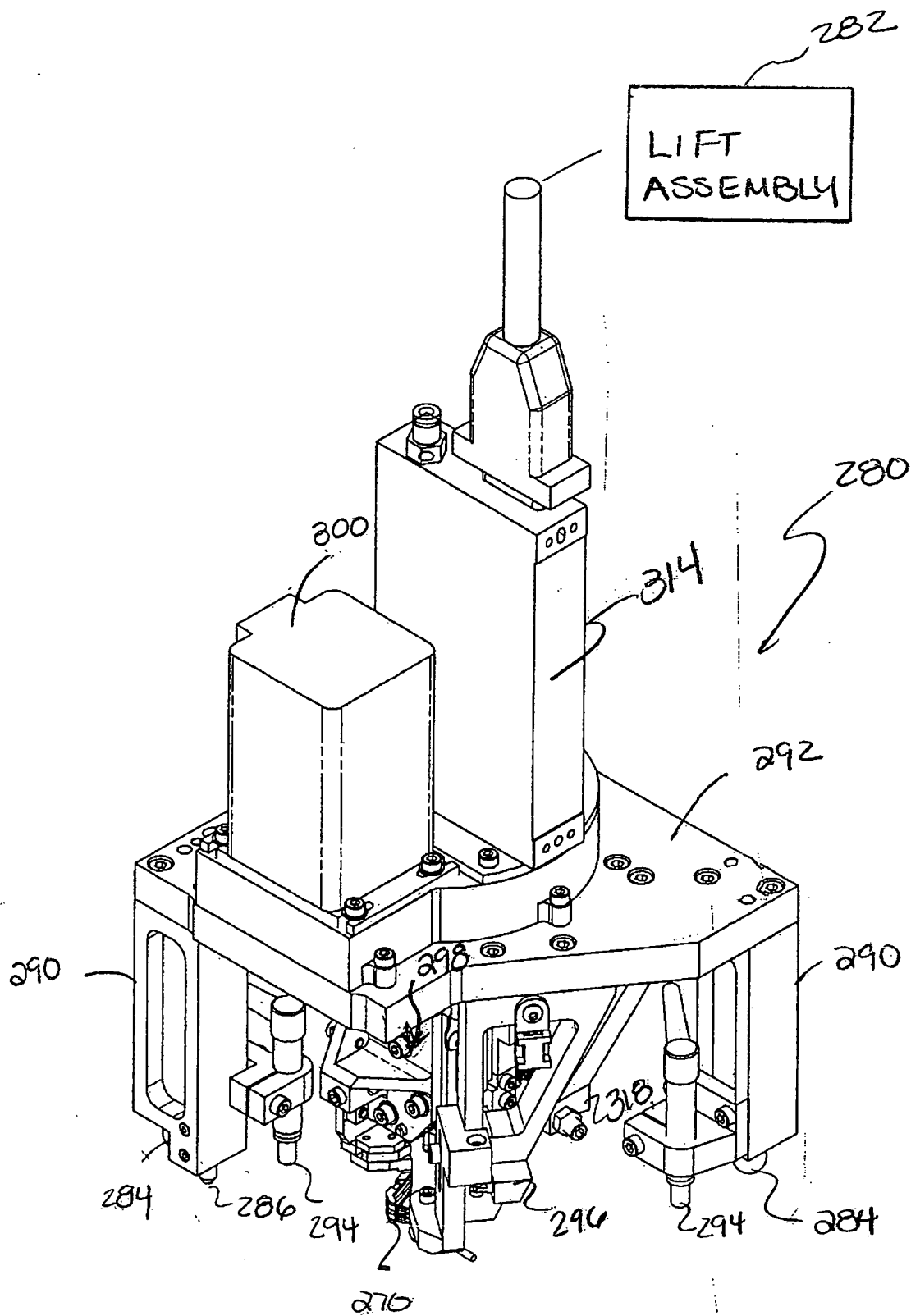


FIG. 10-1

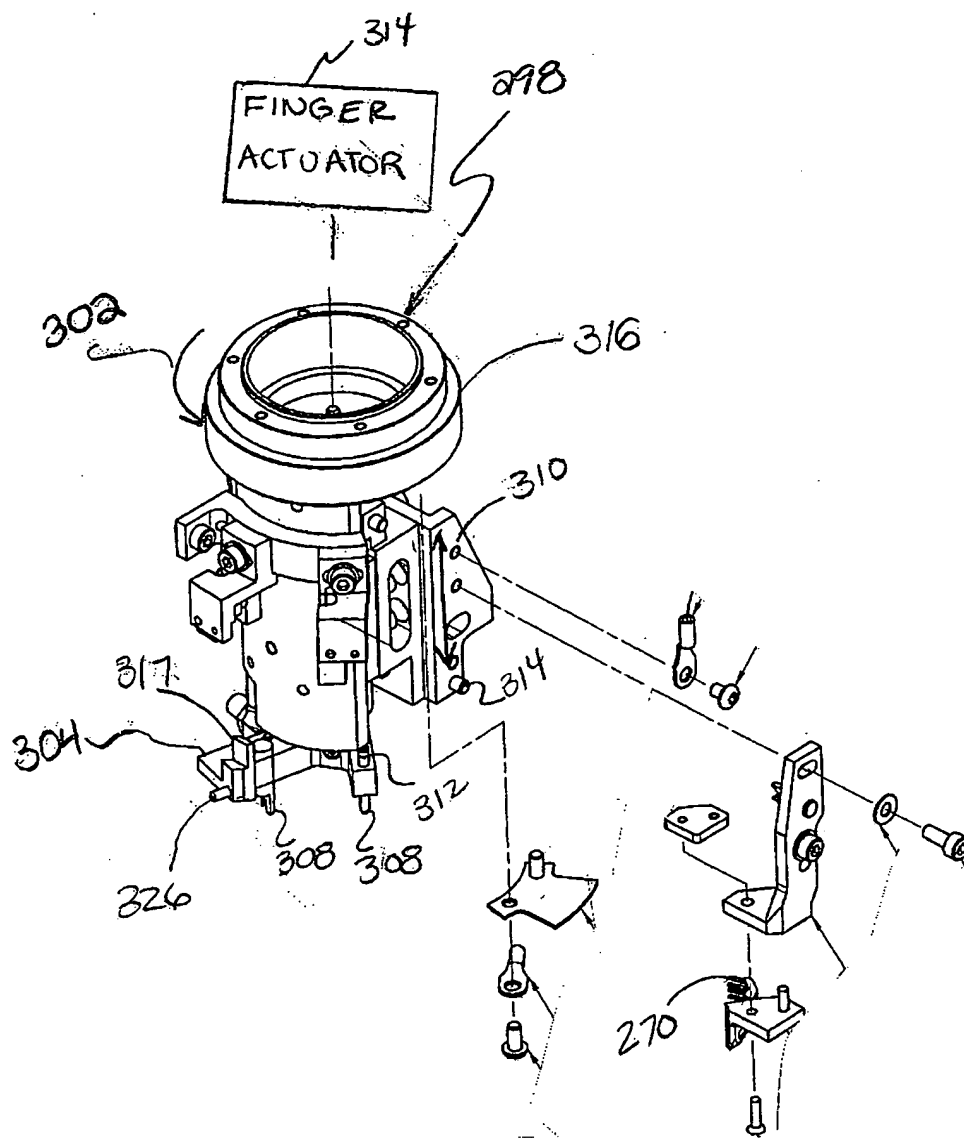


FIG. 10-2

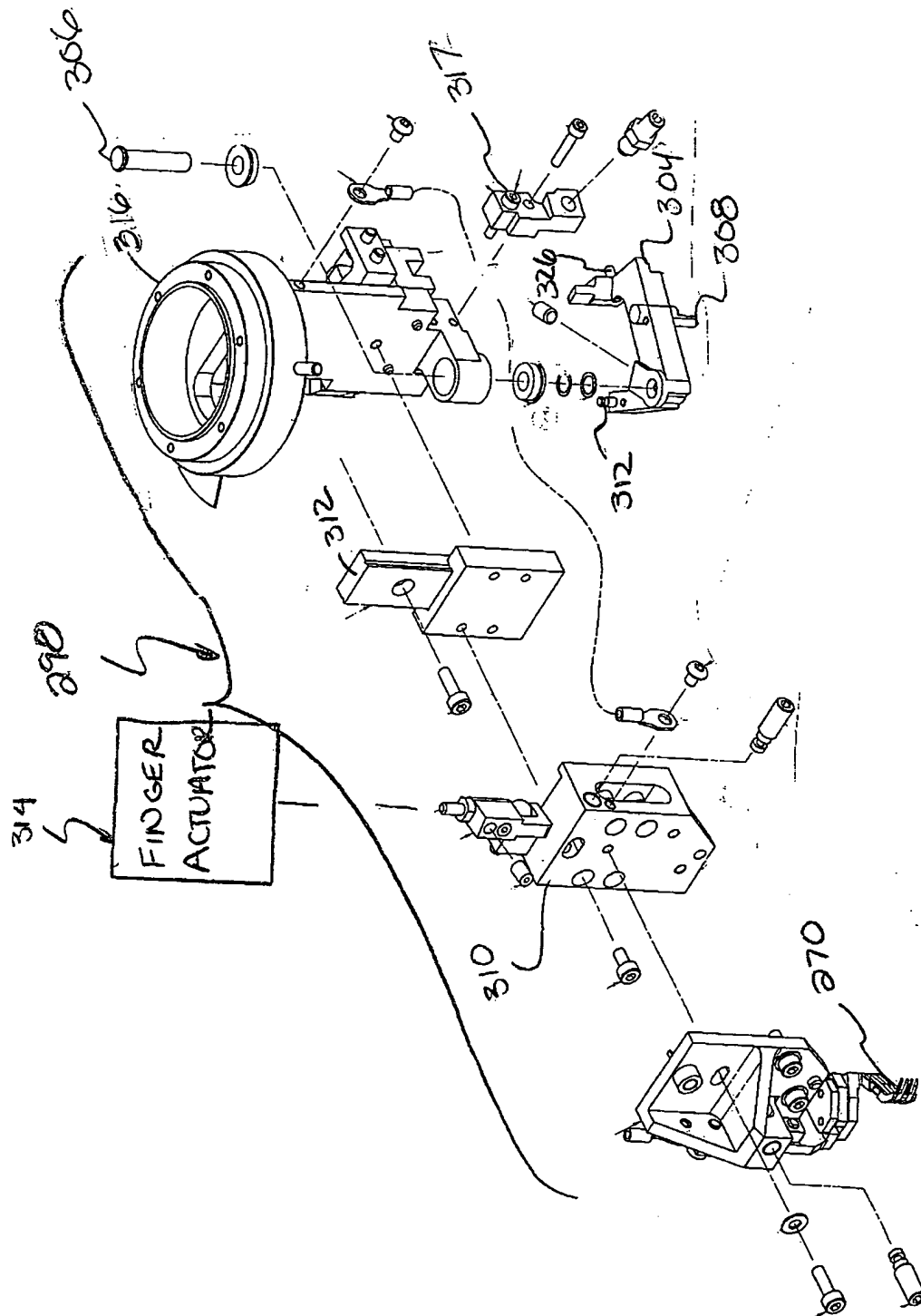


FIG. 10-3

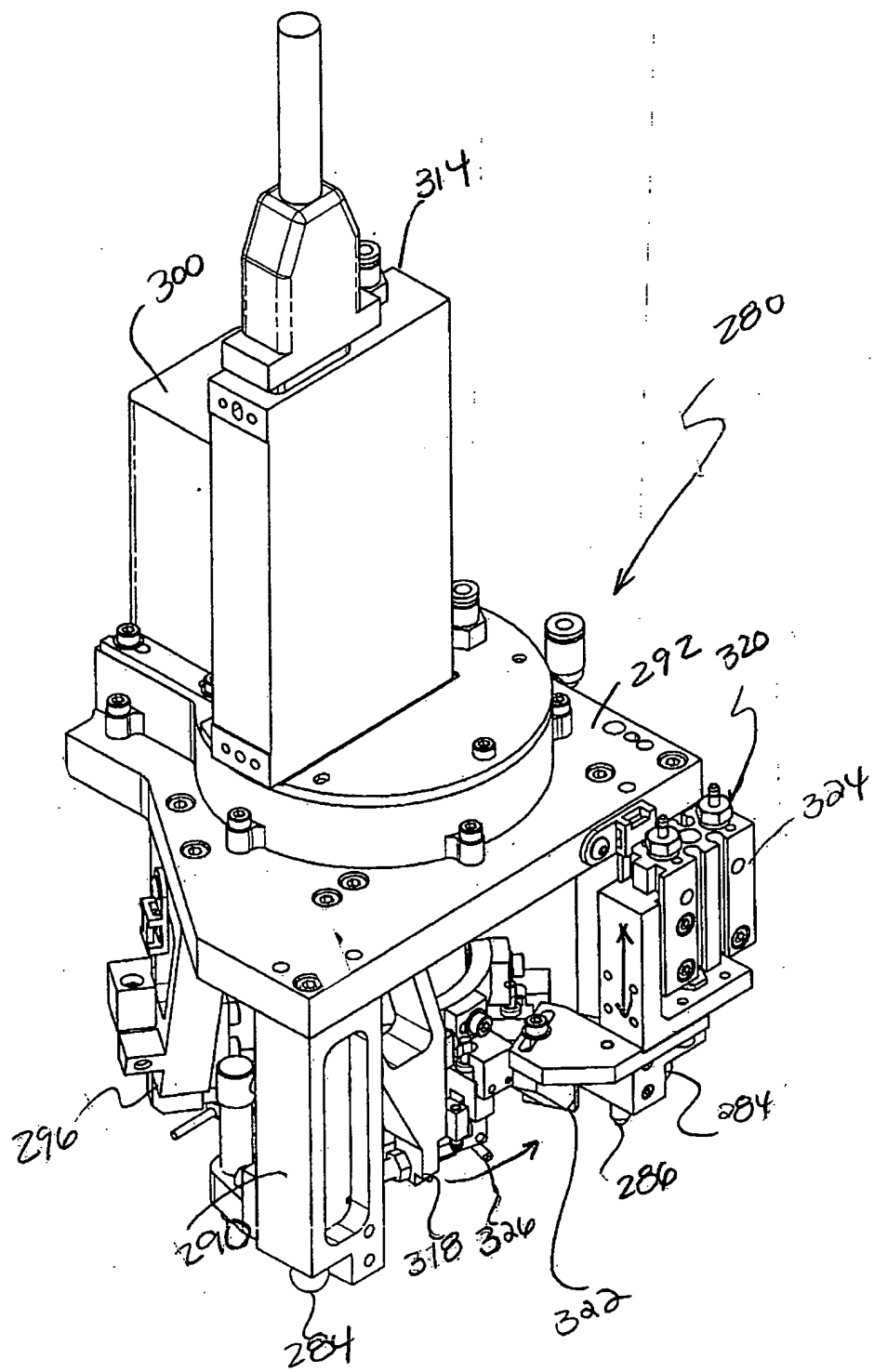


FIG. 10-4

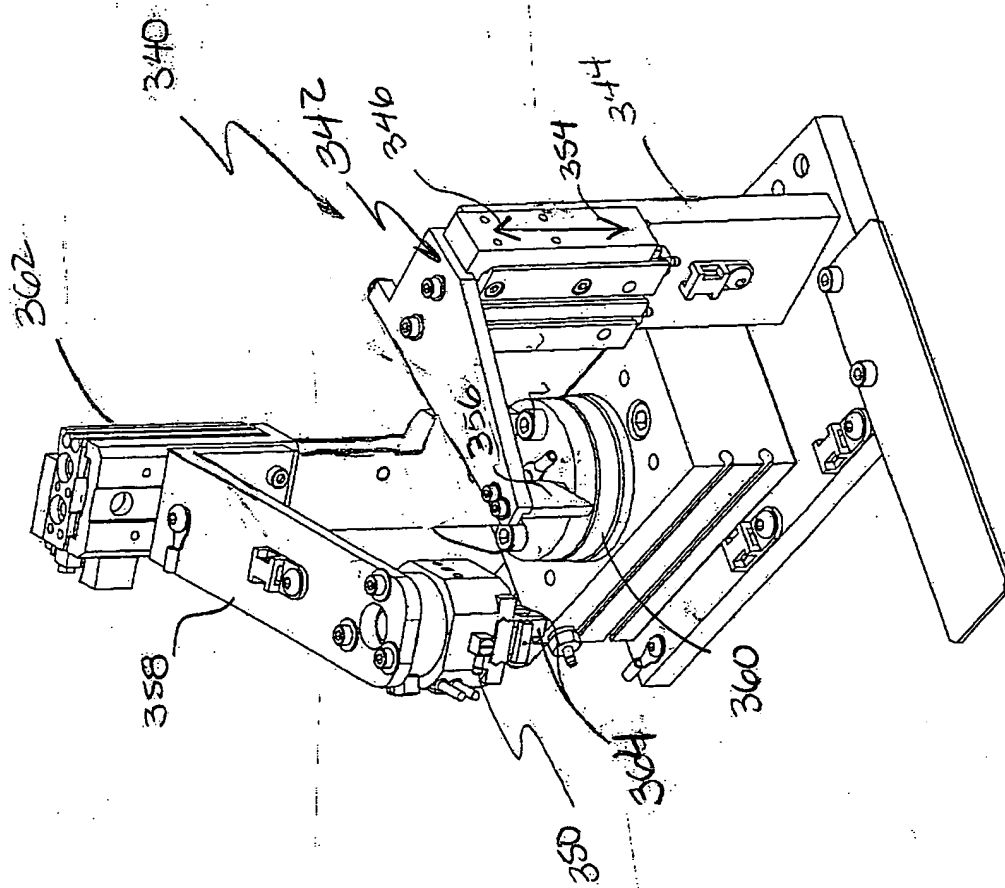


FIG. 11

370

372

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100-1

100-2

100-3

100-4

1.0	INDEX 1 - LIFT/CONVEY
1.1	CONVEY IN/OUT
1.2	CONFIRM HDA POSN.
1.3	LIFT UP
1.4	CLAMP CYLINDER UP
1.5	LIFT DOWN (short)
1.6	ROTATE TABLE
1.7	LIFT UP (short)
1.8	CLAMP CYLINDER DOWN
1.9	LIFT DOWN

2	INDEX 2 - CLOCK HSA
2.1	VISION CHECK 1
2.2	CAM CYLINDER DOWN
2.3	CAM CYLINDER UP
2.4	VISION CHECK 2
2.5	ROTATE TABLE

3	INDEX 3 - MERGE
3.1	LOWER MERGE HEAD
3.2	CHECK SENSORS
3.3	LOWER SPREADER
3.4	VERIFY SPREADER POSN.
3.5	ENGAGE HEADS
3.6	MERGE (SPREADER IN)
3.7	LOWER LATCH CYLINDER
3.8	SET HEADS ON DISCS
3.9	ROTATE SPREADER OUT
3.10	RAISE SPREADER
3.11	RAISE MERGE HEAD
3.12	RAISE LATCH CYLINDER
3.13	INSPECT SPREADER
3.14	ROTATE TABLE

4	INDEX 4 - PICK COMB
4.1	CAM CYLINDER DOWN
4.2	CAM CYLINDER UP
4.3	GRIPPER DOWN
4.4	GRIPPER CLOSE
4.5	GRIPPER UP
4.6	GRIPPER ROTATE OUT
4.7	VISION CHECK 3
4.8	GRIPPER OPEN
4.9	CONFIRM COMB DUMP
4.10	GRIPPER ROTATE IN
4.11	ROTATE TABLE

FIG.12

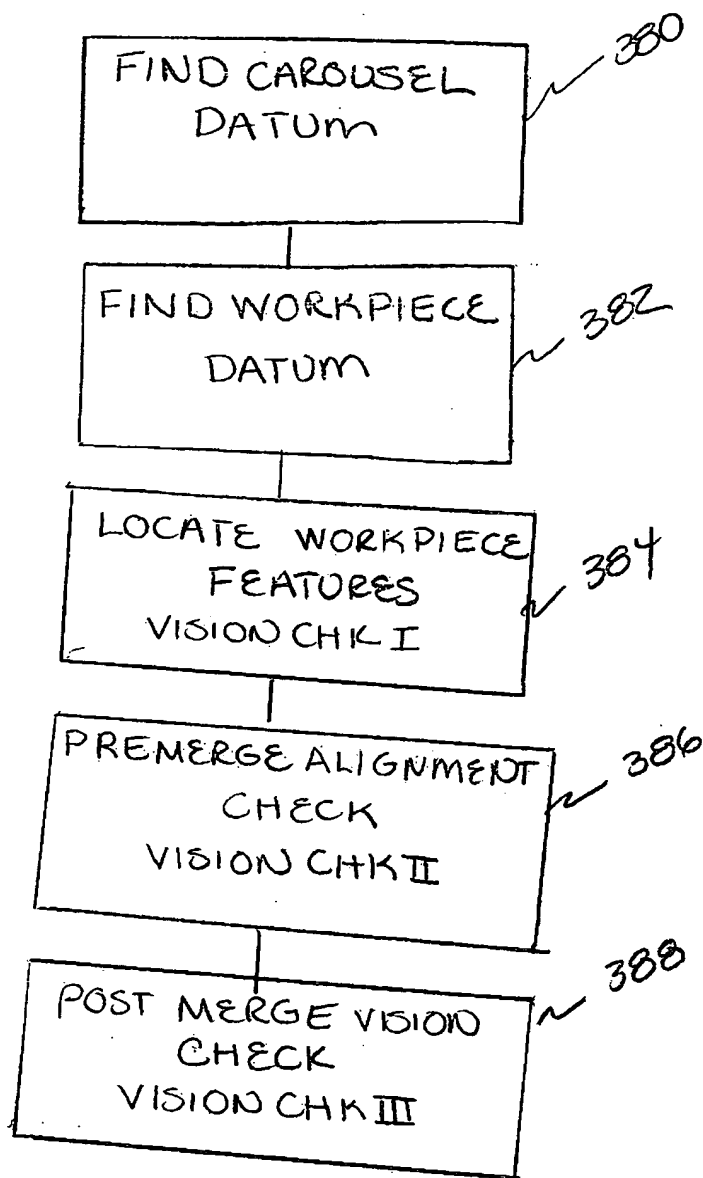


FIG. 13



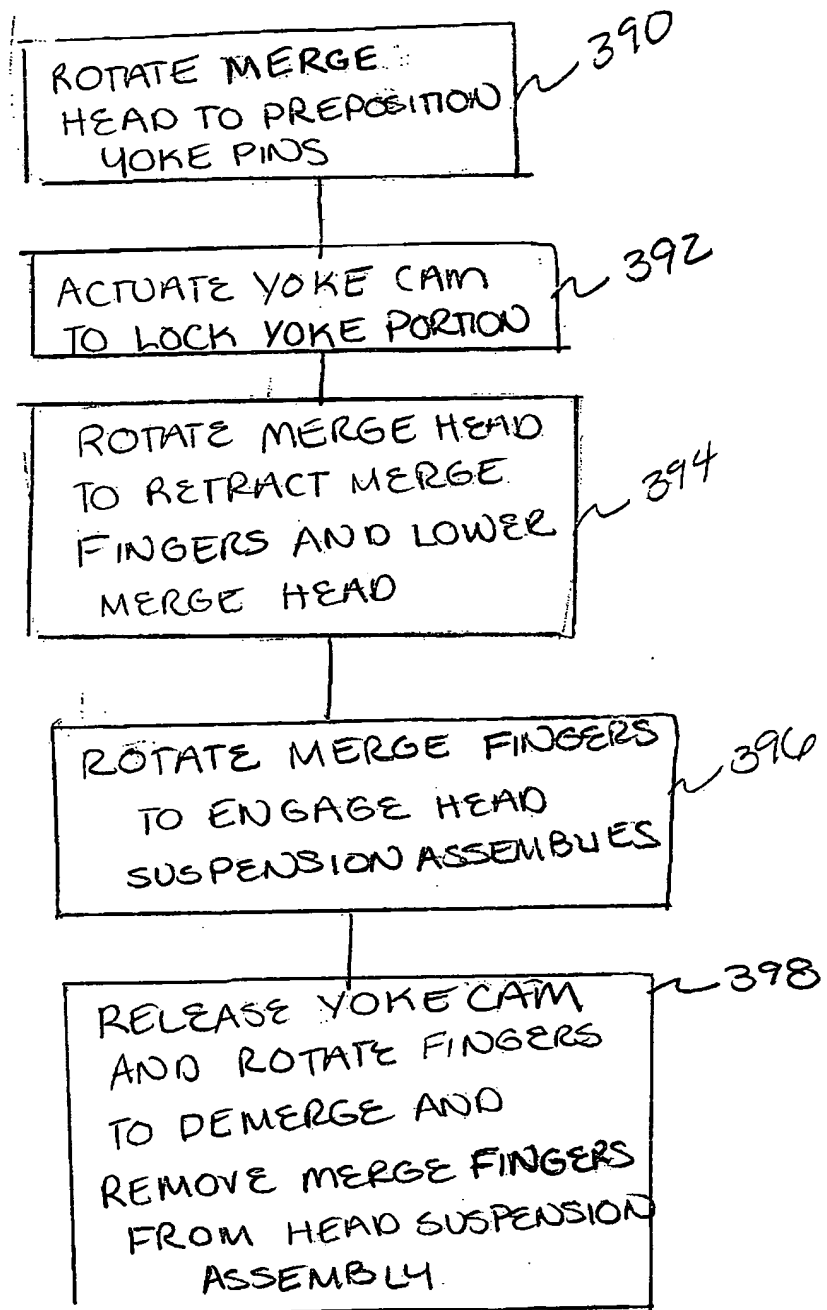


FIG. 14